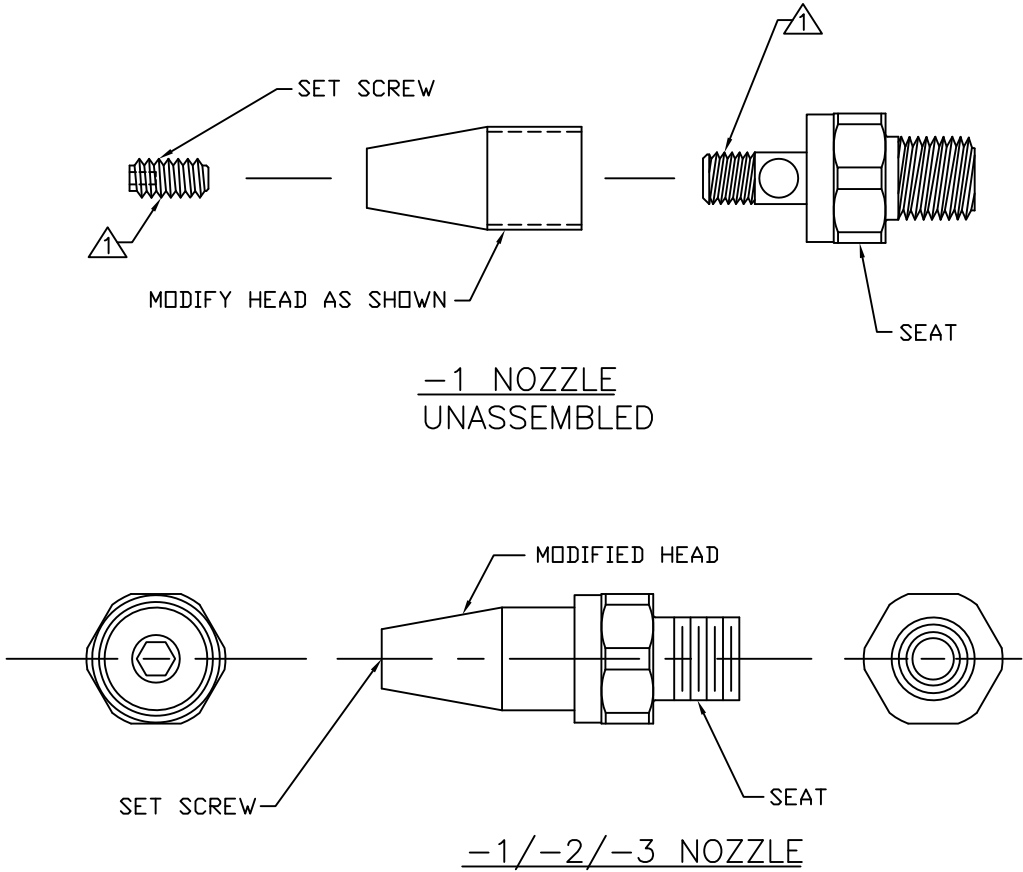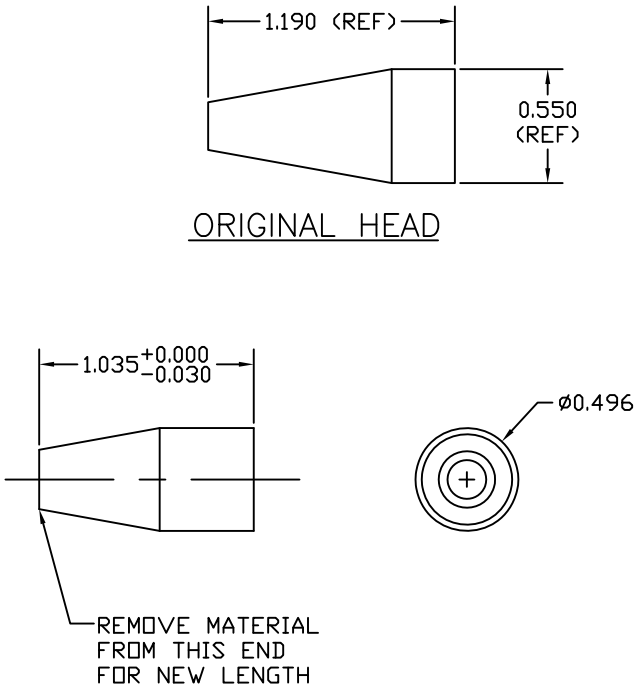MAKE FROM ES77000-1 NOZZLE.
REMOVE HEAD AND MACHINE AS SHOWN.   REINSTALL HEAD AND SCREW ON TO FULLY
CLOSED POSITION.   THEN OPEN $0.036^{+0.005}_{-0.000}$ (−1) TO ACHIEVE PROPER DIMENSION.
$0.005^{+0.001}_{-0.001}$ (−2)
$0.028^{+0.001}_{-0.001}$ (−3)

FINISH: NOZZLE HEAD ONLY: ANODIZE PER MIL-A-8625, TYPE II CLASS 2, COLOR: BLACK.
⚠1 APPLY ANTI SIEZE PER MIL-A-907D OR EQUIVALENT BEFORE ASSY.

SHEET	REV	ECO	DATE	DESCRIPTION	APR	CHK
1	A		06/27/97	ADDED MODIFICATION NOTE	REB	LS
1	B		03/16/00	IDENTIFIED COMPONENTS	MR	LS
1	C		04/08/02	ADDED NOTE 1: ADDED ORIG. HEAD, HEAD MOD'N VIEWS; 1.035 WAS +/−0.010	REB	LS
1		1	07/28/14	CHANGED ANODIZE COLOR TO BLACK; UPDATED LENGTH OF ORIGINAL HEAD WAS 1.085.	JT	LS
1		2	08/20/14	ADDED −2	JT	LS
1	D		12/16/15	ADDED −3		

SET SCREW
MODIFY HEAD AS SHOWN
SEAT

−1 NOZZLE
UNASSEMBLED

MODIFIED HEAD
SET SCREW
SEAT

−1/−2/−3 NOZZLE

1.190 (REF)
0.550 (REF)

ORIGINAL HEAD

$1.035^{+0.000}_{-0.030}$
Ø0.496

REMOVE MATERIAL FROM THIS END FOR NEW LENGTH

HEAD MODIFICATIONS

BREAK ALL SHARP EDGES

PROTO
N/C

Paravion® Technology Inc.

TITLE: NOZZLE
DRAWING NO. S−9007

DIMENSIONS IN INCHES
TOLERANCES EXCEPT WHERE NOTED:
.X = ± .1
.XX = ± .05
.XXX = ± .010
ANGLES = ± 1°
THREADS:
INTERNAL=CLASS 2B
EXTERNAL=CLASS 2A

DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO
RHSM	REB	LS	11/01/96	D	
ECO					

DO NOT SCALE DRAWING

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SHEET 1 OF 1